

Ratna R-350

APPLICATIONS

- Suitable to weld on rail ends and crossing.
- Plough shares, shear plates, brake shoes, cogwheels.
- Conveyer parts, cold punching dies, pulleys and steel casting etc.

DESCRIPTION

- A medium-heavy coated hydrogen-controlled electrode for hard facing applications on mild steel, carbon steel and low alloy steel where approximately 350 brinell hardness is required. The weld deposit is machinable with carbide tools.

CURRENT POLARITY	WELDING POSITION
DC(+), AC	FLAT, HORIZONTAL, VERTICAL, OVERHEAD

TYPICAL WELD METAL MECHANICAL PROPERTIES (ELEMENT %)
HARDNESS BHN (AS WELDED)
350 BHN

SIZE AND CURRENT RECOMMENDATIONS		
SIZE D X L (MM)	SIZE D X L (IN)	CURRENT (AMPS) DC+, AC
2.5mm x 350mm	3/32" x 14"	50-80
3.2mm x 350mm	1/8" x 14"	70-110
4.0mm x 350mm	5/32" x 14"	100-130

RE-DRY CONDITIONS

- Re-dry the electrode at 350°C for 1 hour.

NOTE:
THE INFORMATION PROVIDED IN THIS ARTICLE OR OTHERWISE REFERRED TO HEREIN IS MERELY PROVIDED AS "TYPICAL" WITHOUT ANY ASSURANCE OR PROMISE. ACTUAL RESULTS WILL VARY BASED ON A NUMBER OF VARIABLES, INCLUDING, BUT NOT LIMITED TO, WELD PROCESS, PLATE CHEMISTRY AND TEMPERATURE, WELDMENT DESIGN, AND FABRICATION PROCEDURES. WASHINGTON CENTRAL CORPORATION EXPRESSLY DISCLAIMS ANY LIABILITY SUFFERED FROM ANY RELIANCE THEREON. IT IS ADVISED THAT BEFORE USING ANY WELDING CONSUMABLE OR PROCEDURE IN THE INTENDED APPLICATION, USERS CHECK THEIR COMPATIBILITY THROUGH QUALIFICATION TESTING OR OTHER SUITABLE METHODS.